

ASAP

29

Date: Friday, 6/29/2007 11:17:06 AM
User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|-------------------------------------|-----------------------|------------------|-----------------------|------|-------------|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | : "T" HANDLE ASSEMBLY | | |
| Job Number | 33256A | | | | | |
| Estimate Number | 11179 | | | | | |
| P.O. Number | N/A | | Part Number | : D2282041 | | |
| This Issue | 6/29/2007 | S.O. No. N/A | Drawing Number | : D2282 REV E | | |
| Prsht Rev. | NC | | Project Number | : N/A | | |
| First Issue | N/A | Type : SMALL /MED FAB | Drawing Revision | : E | | |
| Previous Run | 29802A | | Material | : N/A | | |
| Written By | | | Due Date | 7/20/2007 | Qty: | 50 Um: Each |
| Checked & Approved By | | 1A-07.06.29 | | | | |
| Comment | Est Rev A | Removed from 9 Digit | 05-12-02 | JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|------------------|
| 1.0 | D22823 | Tube | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) | |
| | | Pick: | |
| | Qty Part Number | Description Batch | |
| | 1 D2282-3 | Handle tube B33259 | |
| | | | PD 07-07-13 (SD) |
| 2.0 | D22825 | Tube | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) | |
| | | Pick: | |
| | Qty Part Number | Description Batch | |
| | 1 D2282-5 | Handle tube B33260 | |
| | | | PD 07-07-13 (SD) |
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 | |
| | | Comment: LARGE FABRICATION RESOURCE 1 | |
| | | 1-Weld as per D2282-041 'T' Handle Assembly | |
| | | Grind chamfers and ensure full penetration. | |
| | A/R ER316L SS | Filling Rod M102421 | |
| | | Dwg Rev: E | |
| | | | 07/07/13 |

| | | | |
|-----|------------|--------------------------|------------------|
| 4.0 | DO NOT USE | WELD INSPECTION | |
| | | Comment: WELD INSPECTION | PD 07-07-13 (SD) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 6/29/2007 11:17:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 33256A

Part Number: D2282041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SP 07/07/15

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EN 07/07/15 (SO)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

MF 07-07-17

8.0 QC21

FINAL INSPECTION/W/O RELEASE



07/07/17 (SO)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-07-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

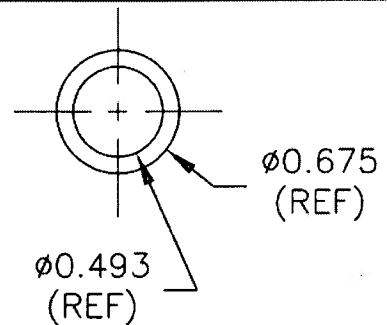
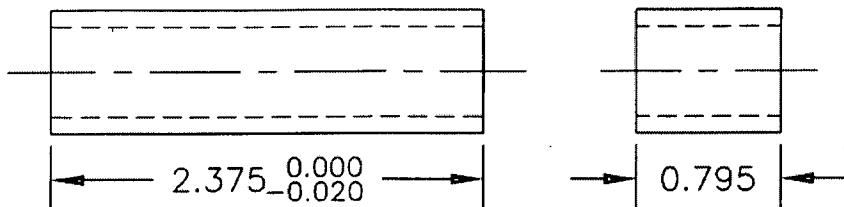
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|-------------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>PZ</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>DP</i> | APPROVED <i>100%</i> | DRAWING NO. D2282 | REV. E SHEET 1 OF 2 |
| DATE 05.06.07 | | TITLE HANDLE TUBES | SCALE 1:1 |
| A | 94.10.14 | NEW ISSUE | |
| B | 95.03.23 | RE-DESIGN | |
| C | 97.10.20 | CORRECTED NUMBERING SCHEME | |
| D | 05.03.16 | REDESIGN D2282-5; 0.795 WAS 0.750 | |
| E | 05.06.07 | D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030 | |



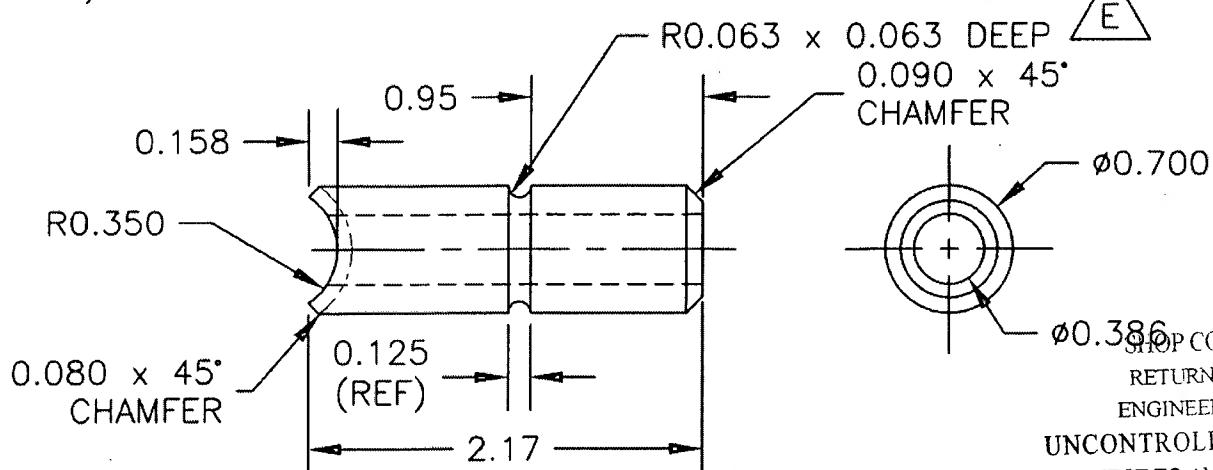
D2282-3

D

D2282-7

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D

D2282-5

D2282-5 STEM:

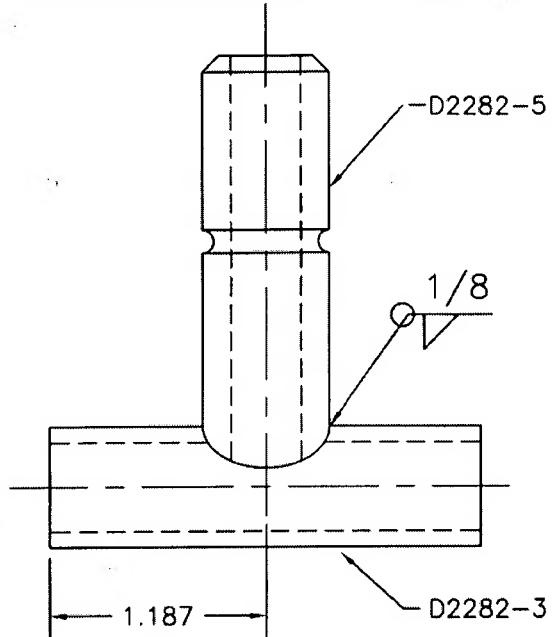
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 33266A

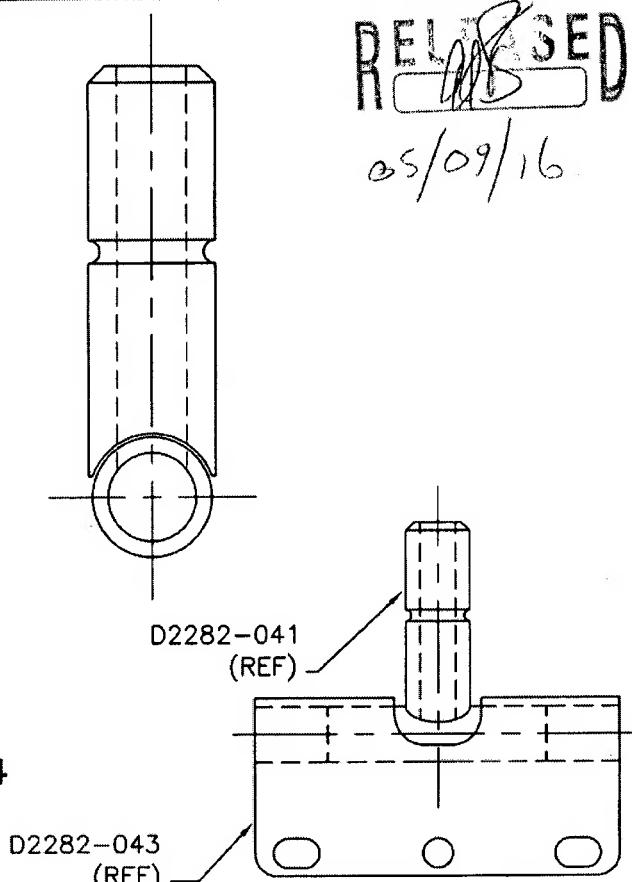
E

DART

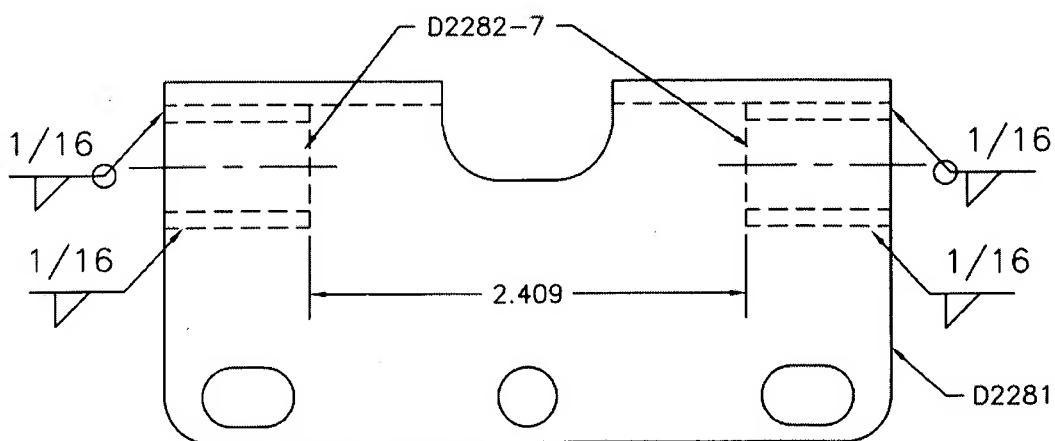
| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>RF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>UP</i> | APPROVED <i>AB</i> | DRAWING NO. D2282 | REV. E SHEET 2 OF 2 |
| DATE 05.06.07 | | TITLE HANDLE TUBES | SCALE 1:1 |



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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